

Work Order ID 55751

January 29, 2010 11:07:26 AM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Basket Base

Start Date: 1/29/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

10-1-29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2221

Rev H

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per
dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: 113328

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

10/02/11 (1x)

10/02/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

S. L. L. L. L.



QC

Memo

0.00



Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

12113170



Powdercoat

Memo

0.00

10/04/16

Powder Coating

Plug holes prior to

1ST COAT:

START TIME: *8:00 AM*

OVEN TEMPERATURE: *400°F*

FINISH TIME: *8:30 AM*

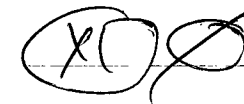
***** 2nd coat if necessary*****

2ND COAT:

START TIME: *8:45 AM*

OVEN TEMPERATURE: *400°F*

FINISH TIME: *9:15 AM*



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Run Start



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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7 M-L 10/02/16



150

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

ES 10/02/16

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/18

MF 10-2-17

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Picklist Print

January 29, 2010 11:07:30 AM

Page 1

Work Order ID: 55751



Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 1/29/10

Required Date: 2/08/10

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2221-1 Manufactured No 100 Each 11.0000 1.0000



Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1

48101

1

Main Warehouse

WA

10

53662

10

1x *SH* 10/02/08 *DR*

D2221-5 Manufactured No 100 Each 6.0000 2.0000



Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

6

54204

6

2x *SH* 10/02/08

D2221-7 Manufactured No 100 Each 3.0000 1.0000



Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

3

54205

3

1x *SH* 10/02/08

W/O:		WORK ORDER CHANGES					
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 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2232-3 Manufactured No 100 Each 29.0000 2.0000



Basket Hinge



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 29

50024 2

54863 27

2x 10/02/08

D2235-1 Manufactured No 100 Each 17.0000 2.0000



Basket Rib



Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA 17

50565 3

54206 4

54864 10

2x 10/02/08

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 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No 100 Each 39.0000 2.0000



Mounting Bracket



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	36	
46086	2	
48428	1	
51120	2	
54862	31	

Main Warehouse

WA	3	
50872	1	
51745	2	

2x *[Signature]* 10/02/08

D3442-1 Manufactured No 100 Each 20.0000 2.0000



Shim



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	1	
46767	1	

Main Warehouse

WA	19	
53386	1	
54071	18	

2x *[Signature]* 10/02/08

W/O:		WORK ORDER CHANGES					
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 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

✓ D3825-041	Manufactured	No	100	Each	0.0000	2.0000	
Rib Assembly (Basket End)							
✓ D3826-041	Manufactured	No	100	Each	2.0000	2.0000	
Rib / Gusset Assembly							

B 55 790 → 2x

JS 10/02/08

B 55 618 → 2x

JS 10/02/08

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

53721

2

✓ D3827-041	Manufactured	No	100	Each	5.0000	1.0000	
Rib Assembly (Inboard)							

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

5

53901

5

✓ D3832-1	Manufactured	No	100	Each	2.0000	1.0000	
Mesh (Base)							

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

54728

2

JS 10/02/08

JS 10/02/09

January 29, 2010 11:07:30 AM

Shop Packet Print

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IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

10.0000

2.0000



Mesh (Base End Face)



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

10

50025

2

54278

8

2x *SM* 10/02/09

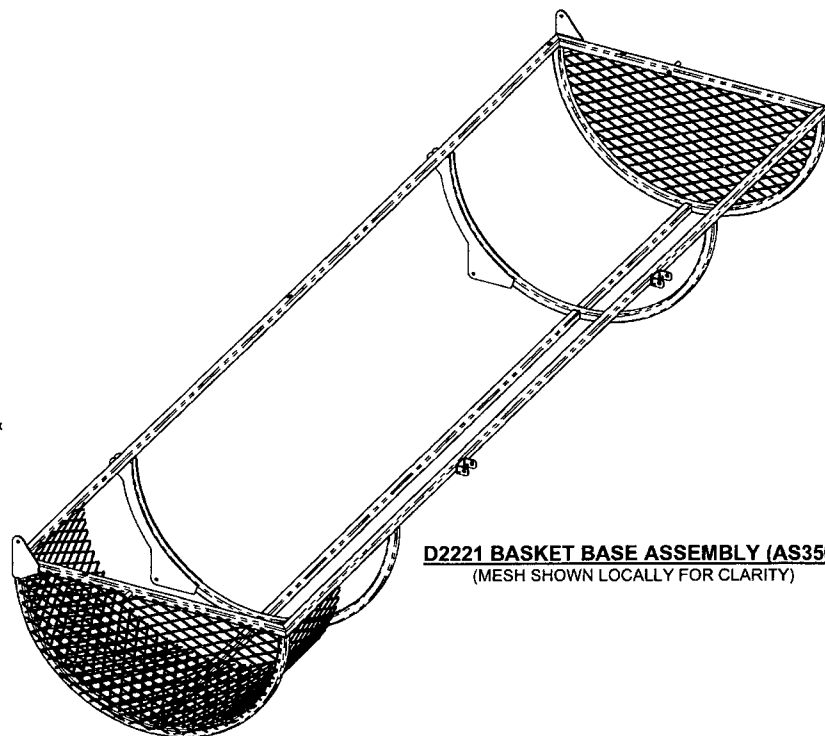
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 55722-55751
10-1-29

RELEASED
08/11/10

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.18
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.05.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BW		
CHECKED	BW	DRAWING NO.	REV. H
MFG. APPR.	BW	D2221	SHEET 1 OF 5
APPROVED	BW	TITLE	SCALE
DE APPR.	BW	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON, WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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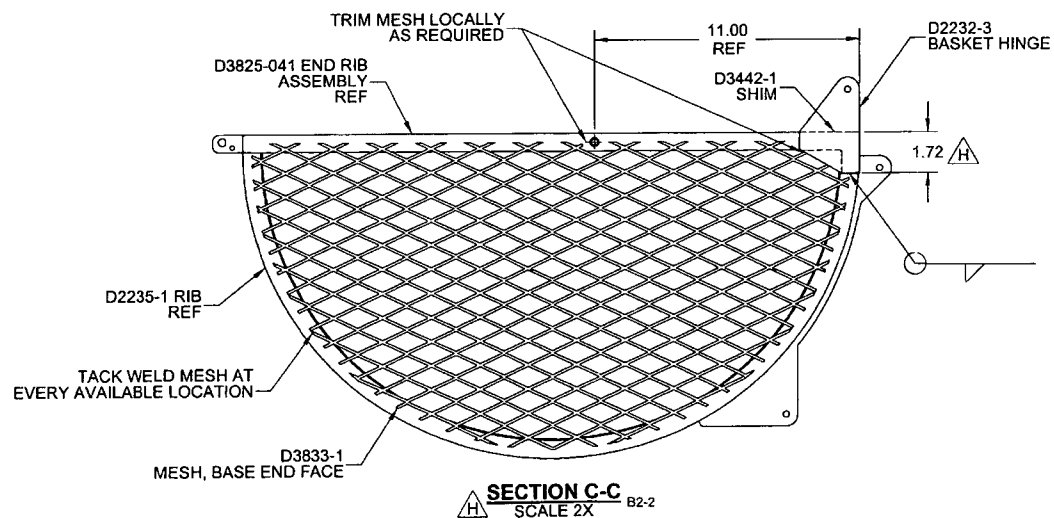
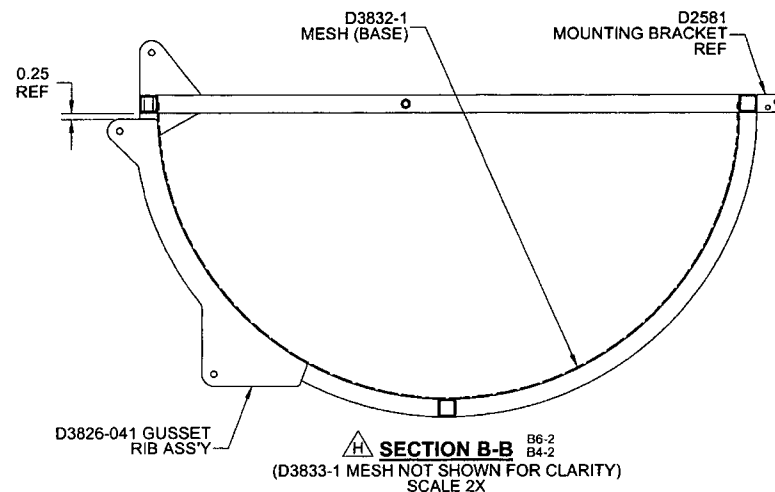
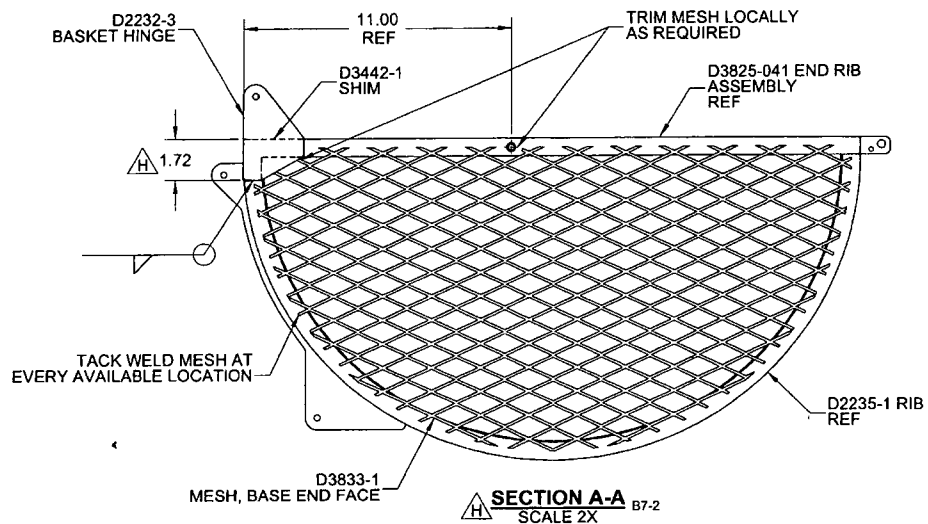
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RELEASED
08/11/16

W10 55751

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS	DRAWING NO. D2221	REV. H
CHECKED			SHEET 3 OF 5
MFG. APPR.		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS
APPROVED		COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.		DATE 08.09.18	

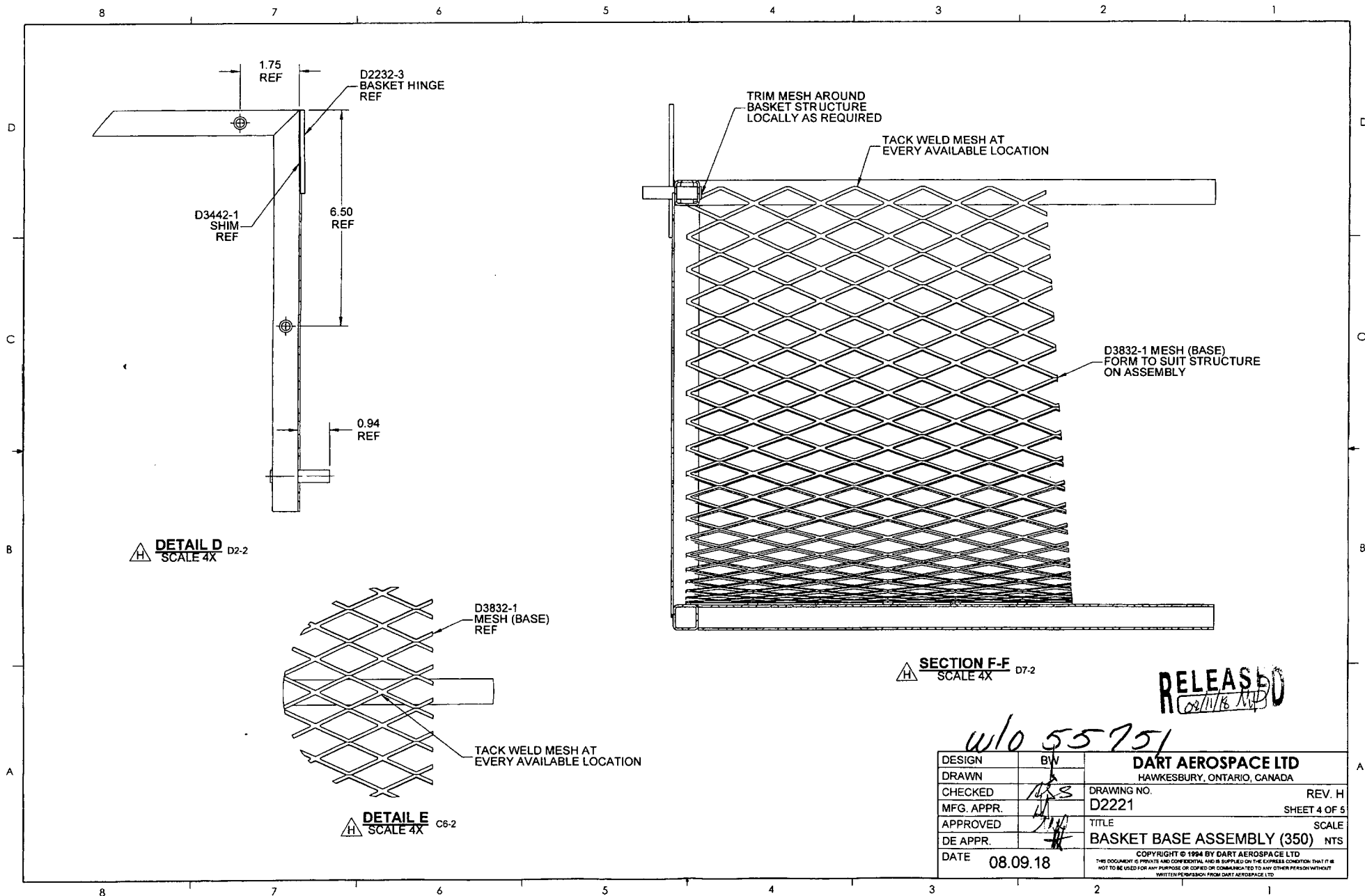
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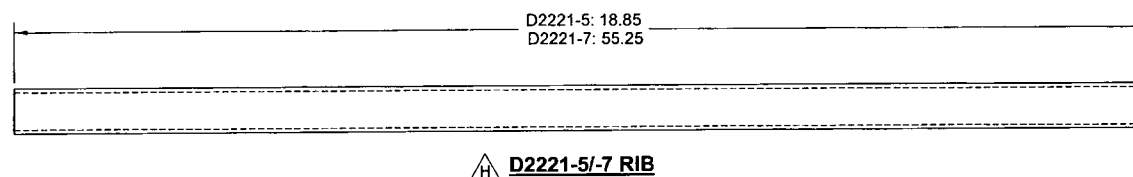
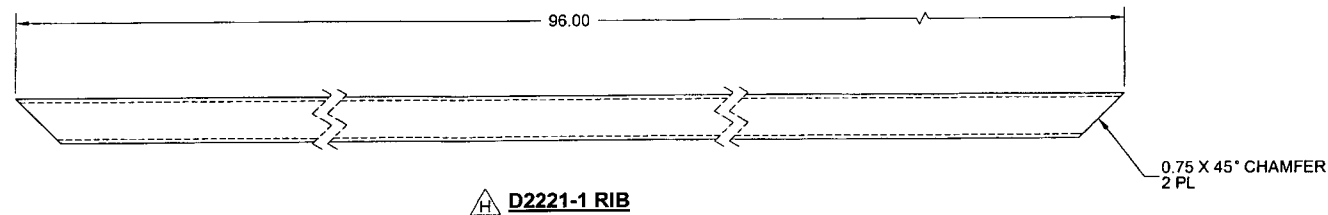
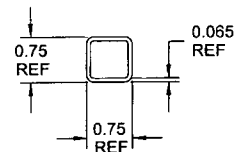
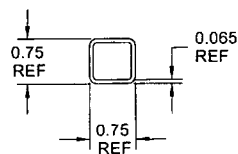
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- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ADS	DRAWING NO.	REV. H
MFG. APPR.	MS	D2221	SHEET 5 OF 5
APPROVED	WJ	TITLE	SCALE
DE APPR.	SH	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

RELEASED
08/11/18 WJ

W1055751

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